

Work Order ID 125782

Wednesday, October 22, 2014 12:35:04 PM

125782

Page 1

Item ID: D4640-15 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ceiling Protector
 Start Date: 10/16/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/21/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-10-22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4640	D								

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

Confirm if parts are trimmed or untrimmed prior to cutting

Cut as per dwg

Prog Rev: D

Dwg Rev: D

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

(1) 14/11/12

(1) 14/11/12
 DAS
 50
 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS 38 9-89
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo USE TEMPLATE TO MARK HOLE LOCATIONS WITH A FINE POINT MARKER ON TEXTURED SIDE	0.00 0.00				1			NOV 20 2014
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: 125030 Memo	0.00 0.00				1	36 3-89		NOV 27 2014
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							14/12/2 DJ ME 14-11-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre-									
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Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Wednesday, October 22, 2014 12:35:04 PM

Page 1

Work Order ID: 125782

125782

Parent Item: D4640-15

D4640-15

Parent Item Name: Ceiling Protector

Start Date: 10/16/14

Required Date: 10/21/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC
12.10.17 AS PER REV.B VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased		No		100	sf	2,555.703	16	17			

MI FXS 093-F6006-07

GE PLASTICS LEXAN SHEET (Grey)

12-14/11/12

Location

Loc Qty

Loc Code

MAT023

2555.70332

114459

229.26

123105

38

124501

543.5

m128668

181.35

m129014

102.33332

m129471

7.31

m129738

1453.95

17

DQA: _____ Date: _____



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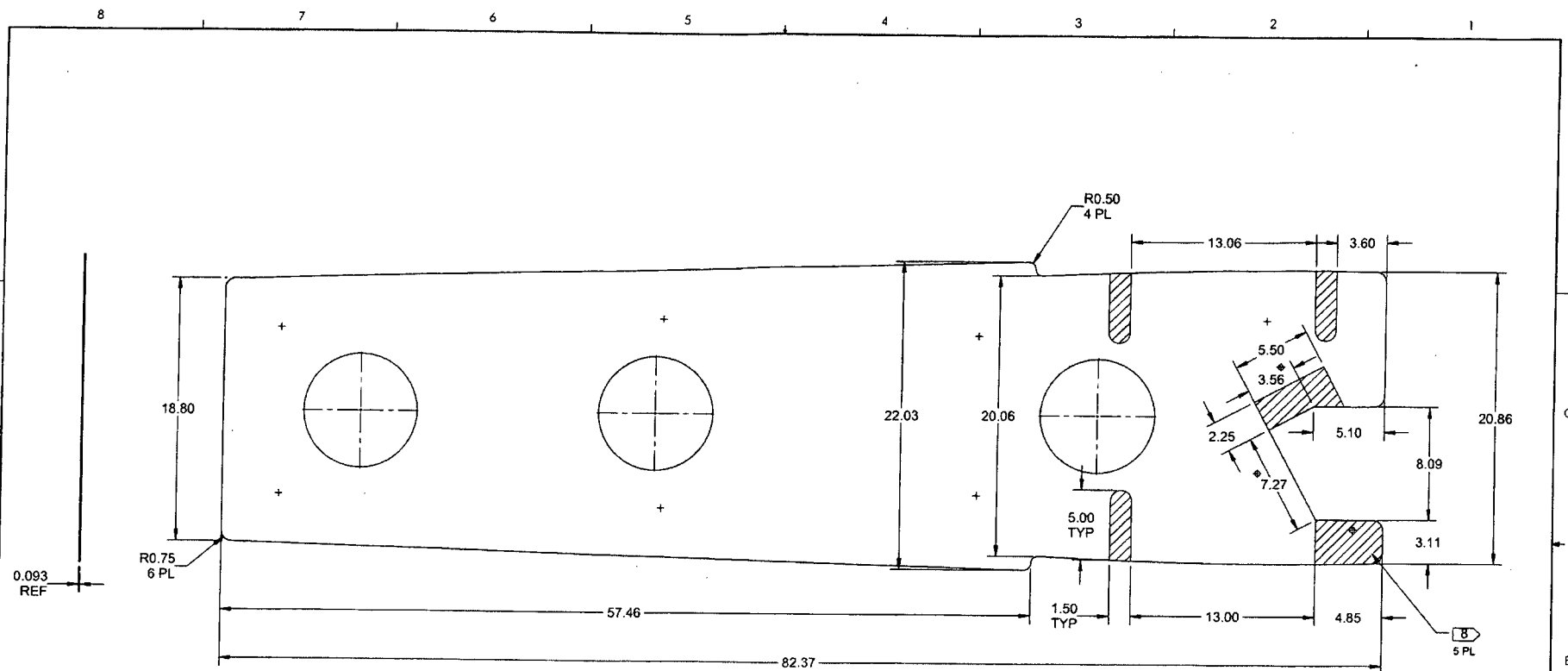
DART AEROSPACE LTD		Work Order: 125782
Description: Ceiling Protector		Part Number: D4640-15
Inspection Dwg: D4640	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.80	+/-0.030	18.80	/		V=DC 02	
22.03	+/-0.030	22.03	/		V=DC 01	
20.06	+/-0.030	20.06	/		Tape	
13.06	+/-0.030	13.06	/			
3.60	+/-0.030	3.60	/			
8.09	+/-0.030	8.09	/			
20.86	+/-0.030	20.86	/			
3.11	+/-0.030	3.11	/			
7.27	+/-0.030	7.27	/			
5.10	+/-0.030	5.10	/			
4.85	+/-0.030	4.85	/			
13.06	+/-0.030	13.06	/			
1.50	+/-0.030	1.50	/			
5.00	+/-0.030	5.00	/			
57.46	+/-0.030	57.46	/			
82.37	+/-0.030	82.37	/			
Ø8.13	+0.012/-0.001	8.13	/			
6.77	+/-0.030	6.77	/			
5.72	+/-0.030	5.72	/			
6.13	+/-0.030	6.13	/			
2.21	+/-0.030	2.21	/			
0.88	+/-0.030	0.88	/			
7.78	+/-0.030	7.78	/			
7.47	+/-0.030	7.47	/			
Ø0.375	+0.006/-0.001	0.380	/			
9.73	+/-0.030	9.73	/			
21.00	+/-0.030	21.00	/			
31.28	+/-0.030	31.28	/			
4.00	+/-0.030	4.00	/			
27.23	+/-0.030	27.23	/			
22.28	+/-0.030	22.28	/			
20.36	+/-0.030	20.36	/			
0.093	+/-0.010	0.093	/			

Measured by: DC 50	Audited by: 38	Preliminary Approval:
Date: 14/09/02	Date: 08/09	Date:

Rev	Date	Change	Revised by	Approved
A	12.09.26	New Issue	KJ	
B	13.02.27	Dwg Rev updated	KJ	



D4640-15 CEILING PROTECTOR
TEXTURED SIDE SHOWN

NOTES:

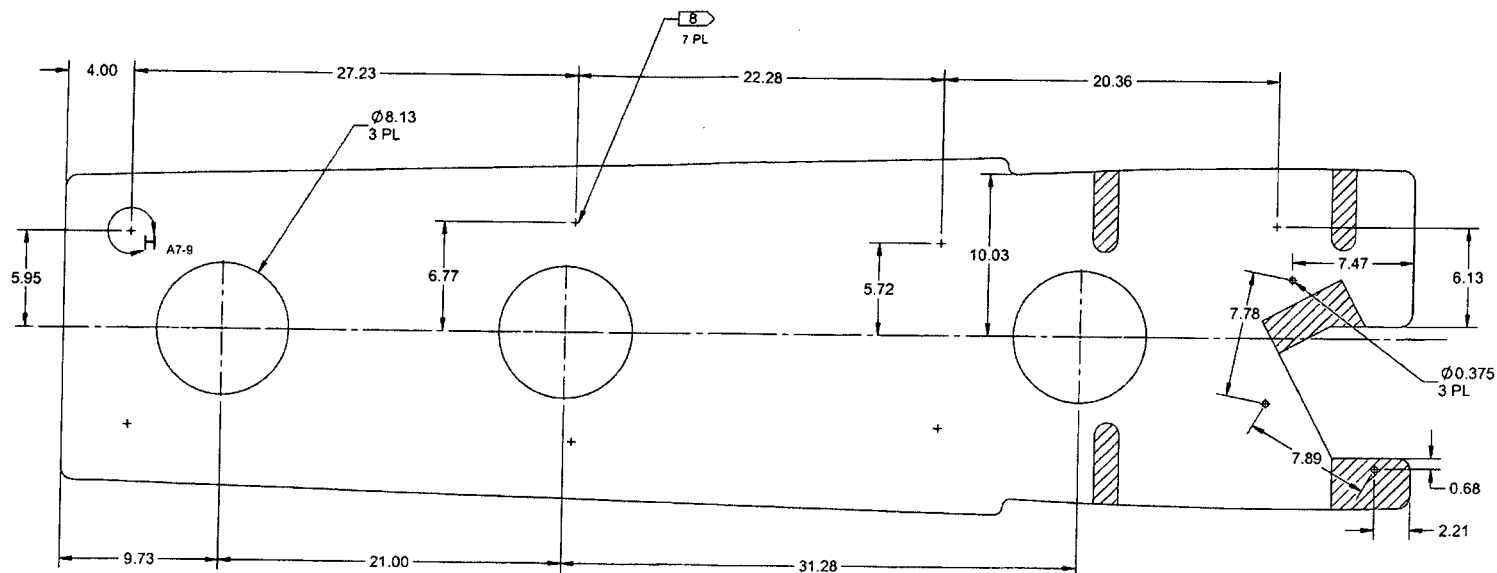
- 1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 5.99 lbs (TRIMMED WEIGHT = 5.78 lbs)
- 8) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER:
- DRAW 0.50" CROSS ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER
- TRIM AND REMOVE SHADED AREAS

FOR COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
REVISIONS

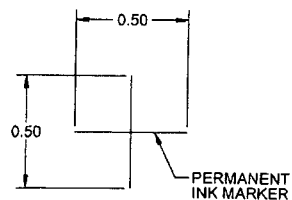
ORDER NOTICE
ORDER
125782 MLW
14-10-22

RELEASED
2013-01-10
MD

DESIGN	XDF	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. D4640	REV. D
MFG. APPR.	JP	SHEET 8 OF 9	
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BAGGAGE PROTECTOR	NTS
DATE	12.12.18	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TO BE REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4640-15 CEILING PROTECTOR
SUPPLEMENTAL VIEW



DETAIL H C7-9
NOT TO SCALE
TRIMMED KIT ONLY

RELEASED
2013-01-10

DESIGN	XDF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO. D4640	REV. D
CHECKED	<i>[Signature]</i>	SHEET 9 OF 9	
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	BAGGAGE PROTECTOR	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	12.12.18		

